

Work Order ID 78857

January-16-12 2:18:49 PM

78857

Page 1

Item ID: D407-802-011

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Crew Door Opener Installation, LH

Stop

NS2

Start Date: 16/01/2012 Start Qty: 3.00

3

Cust Item ID:

Required Date: 30/01/2012 Req'd Qty: 3.00

3

Customer:

Reference:

Approvals: Process Plan: M.L.J

Date: 12/01/16 Tooling:

Date:

Run

Start

NR1

QC:

Date: SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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IIN-D407-802-1	A
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100

100

DOCUMENT CONTROL

0.00

W 12 01 26 (3)

DC

Document Control

Memo

0.00

Photocopy bluefile and create labels per PPP D407-802-011 CHG001

JL for M.L.J 12-1-19 (3)

105

105

Packaging

Pick Kit

0.00

12/11/85 (3)

Packaging

Memo

0.00

110

110

QC

QC4- 100% Inspect kits for completeness

0.00

W 12 01 26 (3)

Quality Control

Memo

0.00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D407-802-011

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Crew Door Opener Installation, LH

Stop

NS2

Start Date: 16/01/2012 **Start Qty:** 3.00

3

Cust Item ID:

Required Date: 30/01/2012 **Req'd Qty:** 3.00

3

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

**Sequence ID/
Work Center ID**

**Operation
Description**

**Set Up/
Run Hours**

Tool ID

Tool #

**Plan
Code**

**Accept
Qty**

**Reject
Qty**

**Reject
Number**

**Insp.
Stamp**

120

120

Packaging

0.00

12/1/26 D/3

Packaging

Memo

0.00

Identify and pack for shipping as per PPPD407-802-011

Location:

PPP rev: A

130

130

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

12/1/26 JF

ME
12-01-26

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Picklist Print

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Work Order ID: 78857

Parent Item: D407-802-011

Parent Item Name: Crew Door Opener Installation, LH

78857
D407-802-011

Start Date: 16/01/2012

Required Date: 30/01/2012

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP Rev:A 10.09.27 new issue DD verf:EC
10.12.02 per revA DD verf:EC

JPP Rev.B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3552-15		Manufactured	No			105	Each	8.0000	1	3	**		

PS *D3552-15*

Door Prop

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST272	8	
65119	8	
105	Each	24.0000
		3
		2
		6
	**	

D3622-5

Ball Stud

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST058	24	
65087	4	
76963	20	
<hr/>	105	Each
		3.0000
		**

D4106-1 *D4106-1*

Sill Doulber, LH

<u>Location</u>	<u>Loc Oty</u>	<u>Loc Code</u>
ST127	3	
<u>64331</u>	3	<u>3</u>
105	Each	3.0000
		1 3
		** 12/19/04 31

M D4106-3
x₃ *D4106-3*
Crew Door Doulber, LH

Crew Door Doulber, LH

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST127	3	
64333	3	3

W/O:		WORK ORDER CHANGES					
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D407-802-011

Parent Item: D407-802-011

Parent Item Name: Crew Door Opener Installation, LH

D4106-5

X3 *D4106-5*
Spacer, Sill Doulber

Manufactured No 105 Each 8.0000

Start Date: 16/01/2012

Start Qty: 3.00

Required Date: 30/01/2012

Required Qty: 3.00

1
3
**

D4106-7

X3 *D4106-7*
Template

Manufactured No 105 Each 1.0000

1
3
**

3
B 74460 SP

CR3523-4-02

X3 *CR3523-4-02*
RIVET

Purchased No 105 Each 455.0000

26
78
**

SP

CR3523-4-4

X3 *CR3523-4-4*
Rivet

Purchased No 105 Each 104.0000

4
12
**

62
16
12/1/12 SP (3)

Location Loc Qty Loc Code

ST313 455
116391 100
116893 3
116915 1
117946 1
117978 200
118680 50
119717 100

Location Loc Qty Loc Code

ST314 104
115768 4
119717 100

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Parent Item: D407-802-011

Parent Item Name: Crew Door Opener Installation, LH

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D407-802-011

Start Date: 16/01/2012

Required Date: 30/01/2012

Start Qty: 3.00

Required Qty: 3.00

CR3523-4-5

CR3523-4-5
Rivet

Purchased No 105 Each 68.0000

13 3 9
**

CR3523-4-6

CR3523-4-6
Rivet

Purchased No 105 Each 76.0000

13 8 24
**

CR3523-4-07

CR3523-4-07
RIVET

Purchased No 105 Each 89.0000

13 7 21
**

MS20426AD4-5

MS20426AD4-5
Rivet

Purchased No 105 Each 5,232.000

13 4 12
**

12/1/12 3

Location Loc Qty Loc Code

ST314 68

117423

68

ST314 76

116606

76

ST314 89

116606

86

ST314 3

17768

3

ST317 165

6733

165

ST317 5067

6874

5067

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Parent Item: D407-802-011

D407-802-011

Parent Item Name: Crew Door Opener Installation, LH

Start Date: 16/01/2012

Required Date: 30/01/2012

MS21073LS
X3 *MS21073I 5*
nut plate

Purchased

No

105

Each

57.0000

1 2
6
**

NAS1149C0532R
X3 *NAS1149C0532R*
WASHER

Purchased

No

Location
ST302
117395

Loc Qty
57
57

Loc Code
617.0000

1 6
18
**

NAS1149C0563R
X3 *NAS1149C0563R*
Washer

Purchased

No

Location
ST297
116373
116513
118384
119736

Loc Qty
617
1
53
163
400

Loc Code
294.0000

1 6
18
**

1/18/13

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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5.0 PARTS LIST

5.1 D407-802-011/-012 Crew Door Opener Kits

<u>Qty</u> -011	<u>Qty</u> -012	Part Number	Description
X		D407-802-011	CREW DOOR OPENER KIT, LH
	X	D407-802-012	CREW DOOR OPENER KIT, RH
1	1	D3552-15	DOOR PROP }
2	2	D3622-5	BALL STUD }
1		D4106-1	SILL DOUBLER, LH }
	1	D4106-2	SILL DOUBLER, RH }
1		D4106-3	CREW DOOR DOUBLER, LH }
	1	D4106-4	CREW DOOR DOUBLER, RH }
1	1	D4106-5	SPACER, SILL DOUBLER }
1	1	D4106-7	TEMPLATE }
26	26	CR3523-4-2	RIVET }
4	4	CR3523-4-4	RIVET }
3	3	CR3523-4-5	RIVET }
8	8	CR3523-4-6	RIVET }
7	7	CR3523-4-7	RIVET }
4	4	MS20426AD4-5	RIVET }
2	2	MS21073L5	ANCHOR NUT }
6	6	NAS1149C0532R	WASHER }
6	6	NAS1149C0563R	WASHER }